

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023211**Date Inspected:** 01-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 13AW and Seg 13BW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: OBW13-001 [Deck Panel (DP) to DP, CJP splice weld]. The welder is identified as 066421 and was observed welding in 1G position. ZPMC Quality Control (QC) was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-T-2232(1)T-ESAB.

OBG Sge13AE:

ABF personnel performing Magnetic Particle Testing (MT) after removal of temporary attachments from Deck Panel (at Seg 13AE and Seg 12CE). See attached photo for further details.

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ZPMC performing base metal repair welding after removal of temporary attachments from Side Panel [Cross Beam (CB) side; at Seg 12CE and Seg 13AE complete joint penetration (CJP) splice weld]. Repair welding was done as per Critical Welding Repair Report (CWR) 2861 Rev-0. Welder was identified as 044504, performing Shielded Metal Arc Welding (SMAW) welding. ZPMC QC was identified as Liu Hua Jie.

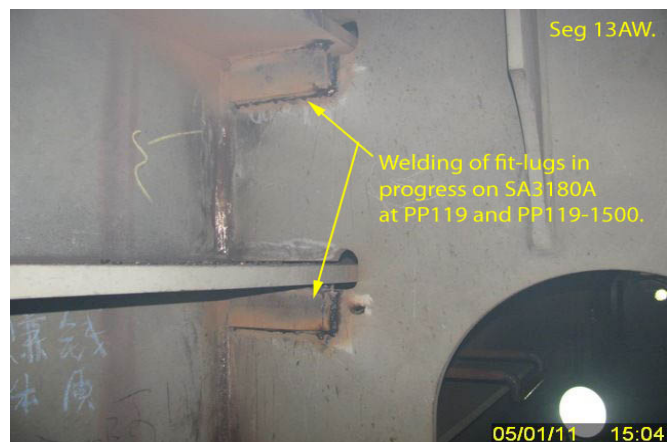
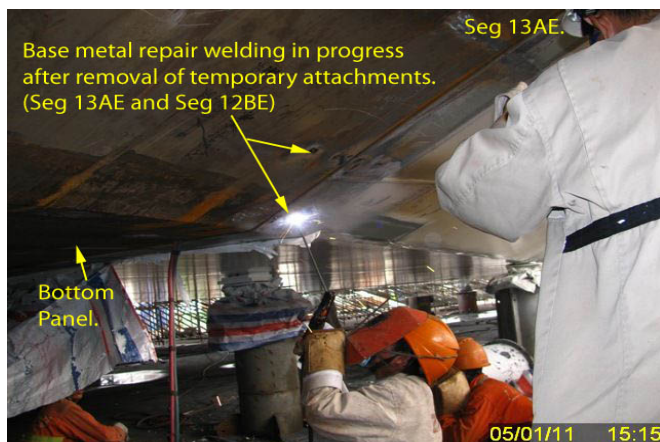
OBG Seg 13AW:

ZPMC personnel performing welding of Fit-up lugs on Sub-Assembly (SA) 5180A at Panel Point (PP) 119-1500 and PP119. See attached photo for further details.

OBG Seg 14E:

This QA Inspector observed that Ultrasonic Testing (UT) of Vertical Shear Plates (VSP) to Top Anchorage Plate is completed. UT of Top Anchorage Plate to Anchor Plate is balance.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable Contract documents.



## Summary of Conversations:

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No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art
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QA Reviewer
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